

*BLUE*

Date: Monday, 17/11/2008 1:53:28 PM  
User: Julie Dawson

**Process Sheet**

|                                  |   |                         |                           |
|----------------------------------|---|-------------------------|---------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services   | <b>Drawing Name</b>     | : 206L /407 STEP ASSY, RH |
| <b>Job Number</b>                | : 43490A                                | <b>Part Number</b>      | : D2724042                |
| <b>Estimate Number</b>           | : 11703                                 | <b>Drawing Number</b>   | : D2724 REVC              |
| <b>P.O. Number</b>               | :                                       | <b>Project Number</b>   | :                         |
| <b>This Issue</b>                | : 17/11/2008                            | <b>S.O. No.</b>         | :                         |
| <b>Prsht Rev.</b>                | : NC                                    | <b>Drawing Revision</b> | : C                       |
| <b>First Issue</b>               | : / /                                   | <b>Material</b>         | :                         |
| <b>Previous Run</b>              | : 39838A                                | <b>Due Date</b>         | : 02/02/2009              |
| <b>Written By</b>                | :                                       | <b>Qty:</b>             | 4 Um: Each                |
| <b>Checked &amp; Approved By</b> | : <u>JUD 08.11.17</u>                   |                         |                           |
| <b>Comment</b>                   | : Est Rev:E As Per Ecn 766 06-01-06 JLM |                         |                           |

**Additional Product**

Job Number:



**Seq. #:**      **Machine Or Operation:**      **Description :**

1.0      D2622120C      Step Extrusion



**Comment:** Qty.: 1.0000 Each(s)/Unit    Total : 1.0000 Each(s)

|     |            |             |               |
|-----|------------|-------------|---------------|
| Qty | Part #     | Description | Batch:        |
| 1   | D2622-120C | Extrusion   | <u>B42155</u> |

Check Material for any Dents or Defects

*SAD 08-12-29* (4)

2.0      LARGE FAB 1      LARGE FABRICATION RESOURCE 1



**Comment:** LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724  
Deburr and bevel ends for welding

*SAD 08-12-29* (4)

3.0      D2734      Step End Plate



**Comment:** Qty.: 2.0000 Each(s)/Unit    Total : 2.0000 Each(s)

206 Step Endplate

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 2   | D2734       | End Cap     | <u>B39179</u> |

*PK 08.12.30* 4

4.0      D34581      Step Mounting Plate



**Comment:** Qty.: 2.0000 Each(s)/Unit    Total : 2.0000 Each(s)

Pick:

|     |             |             |               |
|-----|-------------|-------------|---------------|
| Qty | Part Number | Description | Batch         |
| 2   | D3458-1     | Plate       | <u>B43085</u> |

*PK 08.12.30* 4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 17/11/2008 1:53:29 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43490A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D34583 Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

2 D3458-3

Description:

Plate

Batch

343086

*PH 08.12.30*

4

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: *M108037*

Grind end cap welds flush

*PH 08.12.30*

4

*PH 08.12.30*

4

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PH 08.12.30*

4

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PH 08.12.30*  
*(R14)*

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*PH 08.12.30*

4

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*PH 08.12.30*

4

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

*PH 09.1.5*

4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 17/11/2008 1:53:29 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43490A

Part Number: D2724042

Job Number:



Seq. #: Machine Or Operation: Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M102031

Grind end plate flush.

*Handwritten:* 09-01-05 4  
09-01-05 4

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 09-01-05 4

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 09/01/06 (x4) 16

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

*Handwritten:* 09/01/07 (4)

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B110199

-SPRAY PAINT DELFLEET BLUE

B110077

-CLEAR DELFLEET

B110161

*Handwritten:* 09 01 15 (4)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

*Handwritten:* 09/01/06 (x4) (210)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

*Handwritten:* M110459

*Handwritten:* 09.01.16 (4)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 09-01-14 (x4)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 43490A

Part Number: D2724042

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*PPP4 3420 09/01/28 (9)*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



*09/02/02*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-01-29*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

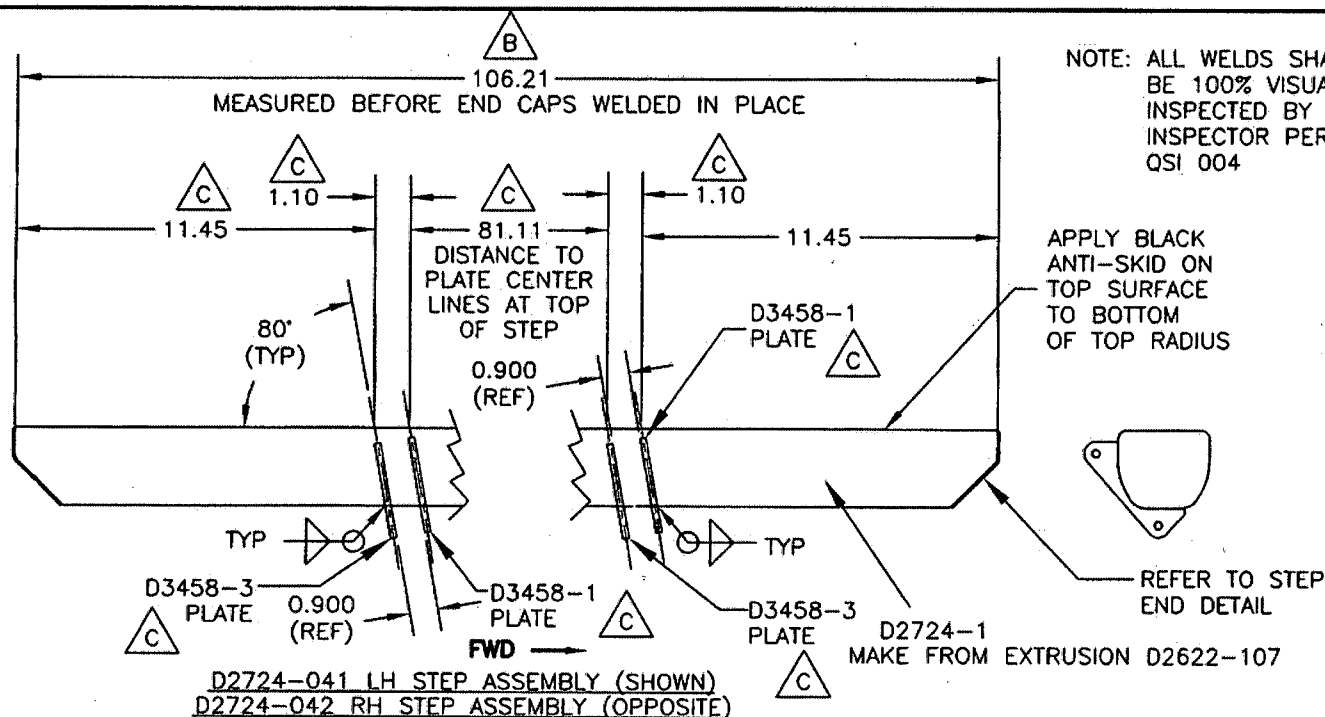
NOTE: Date & initial all entries





RELEASED  
05.11.14

NOTE: ALL WELDS SHALL  
BE 100% VISUALLY  
INSPECTED BY A QUALIFIED  
INSPECTOR PER DART  
QSI 004



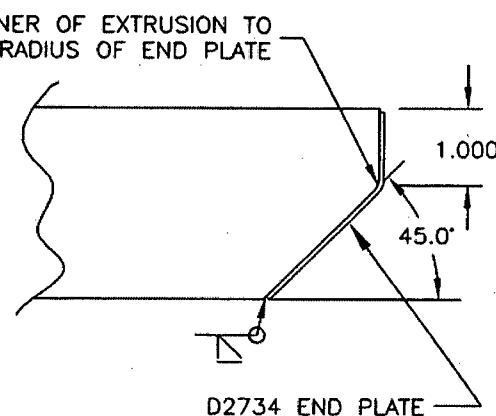
#### D2721-041/-042 STEP ASSEMBLY PARTS LIST

| QTY<br>-041 | QTY<br>-042 | PART NUMBER | DESCRIPTION      |
|-------------|-------------|-------------|------------------|
| X           | X           | D2724-041   | LH STEP ASSEMBLY |
|             | X           | D2724-042   | RH STEP ASSEMBLY |
| 1           | 1           | D2622-107   | EXTRUSION        |
| 2           | 2           | D2734       | END PLATE        |
| 2           | 2           | D3458-1     | PLATE            |
| 2           | 2           | D3458-3     | PLATE            |

#### D2724-041/-042 STEP ASSEMBLY:

- 1) MAKE FROM EXTRUSION D2622.
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
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CONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
DATE 01/31/04  
BY 132908



| DESIGN  | KE       | DRAWN BY | PH  | DART AEROSPACE USA, INC.  |
|---------|----------|----------|---|---------------------------|
| CHECKED |          | APPROVED |   | PORT HADLOCK, WA          |
| DATE    | 05.09.19 | TITLE    | D2724                                     | RE-DESIGN, ADD D3458-1/-3 |
|         | A        | 97.12.04 | NEW ISSUE                                 |                           |
|         | B        | 98.10.19 | UPDATED WELD DETAIL<br>REVISED TOLERANCES |                           |
|         | C        | 05.09.19 | 206L/407 STEP ASSEMBLY                    |                           |
|         |          |          | SCALE                                     |                           |
|         |          |          | NTS                                       |                           |
|         |          |          | SHEET 1 OF 1                              |                           |
|         |          |          | REV. C                                    |                           |